


# Clamp Pressure Settings - All Machines

Manufacturer advice on clamp pressure settings

## Contents

Comments

 ...Clamp settings are quoted in "bar". Newer regulators have a MPa scale where 1 bar=0.1MPa

### Machining Centre

Clamp Name	Numbering / Ref	Factory Setting (bar)	Notes
Infeed Top		2.5	
Infeed Side		2.5	
Outfeed Top		2.5	
Outfeed Side		2.5	
V Notch		6	
ZX5 Infeed Clamp Pad			
Gripper Standard		6	Can be reduced if inner webs are crushed, but needs to be strong enough to grip see TB0257 Fault Finding Gripper Slip
Gripper TruLoc		1	
ZX5 Infeed Wheel		1	The weight of the wheel system should be enough to produce enough friction. Too much pressure on this system causes damage to the rollers beneath

### Saw Side

Clamp Name	Numbering / Ref	Factory Setting (bar)	Notes
Infeed Top (Low Pressure)		1.5	The infeed top clamp switches between high and low pressure modes. The low pressure setting should keep the profile pressed down as it advanced through the machine
Side Clamp		3	
Centralise Clamp		3	
Infeed Channel On		1	
Infeed Channel off		2	

### Autoflow Infeed

Clamp Name	Numbering / Ref	Factory Setting (bar)	Notes

